

Date: Monday, 9/25/2006 11:07:27 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RADIUS BLOCK		
Job Number	: 28713					
Estimate Number	: 10822					
P.O. Number	: N/A		Part Number	: D2274		
This Issue	: 9/25/2006 S.O. No. : N/A		Drawing Number	: D2274 REV F		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: F		
Previous Run	: 28344		Material	: N/A		
Written By			Due Date	: 10/2/2006 Qty: 500 Um: Each		
Checked & Approved By						
Comment	: Est. H 00.05.19		Added inspection level 8 EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"		
		Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125"		
		Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch	<u>M101694</u>	<u>06/10/03</u>
2.0	SHEAR	SHEAR		
		Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces	<u>06/10/03</u>	<u>506</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	<u>06/10/20</u>	<u>500</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>06/10/20</u>	<u>500</u>
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	<u>J-G</u>	<u>06/10/26</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

mlc/11/06 500

mlc 06/10/25 500

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m. Jl

06/11/09 X 504

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FB 06/11/10

SD4

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST35

RS 06/11/10

504

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DA 06/11/10

504

Job Completion



4/20/10

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

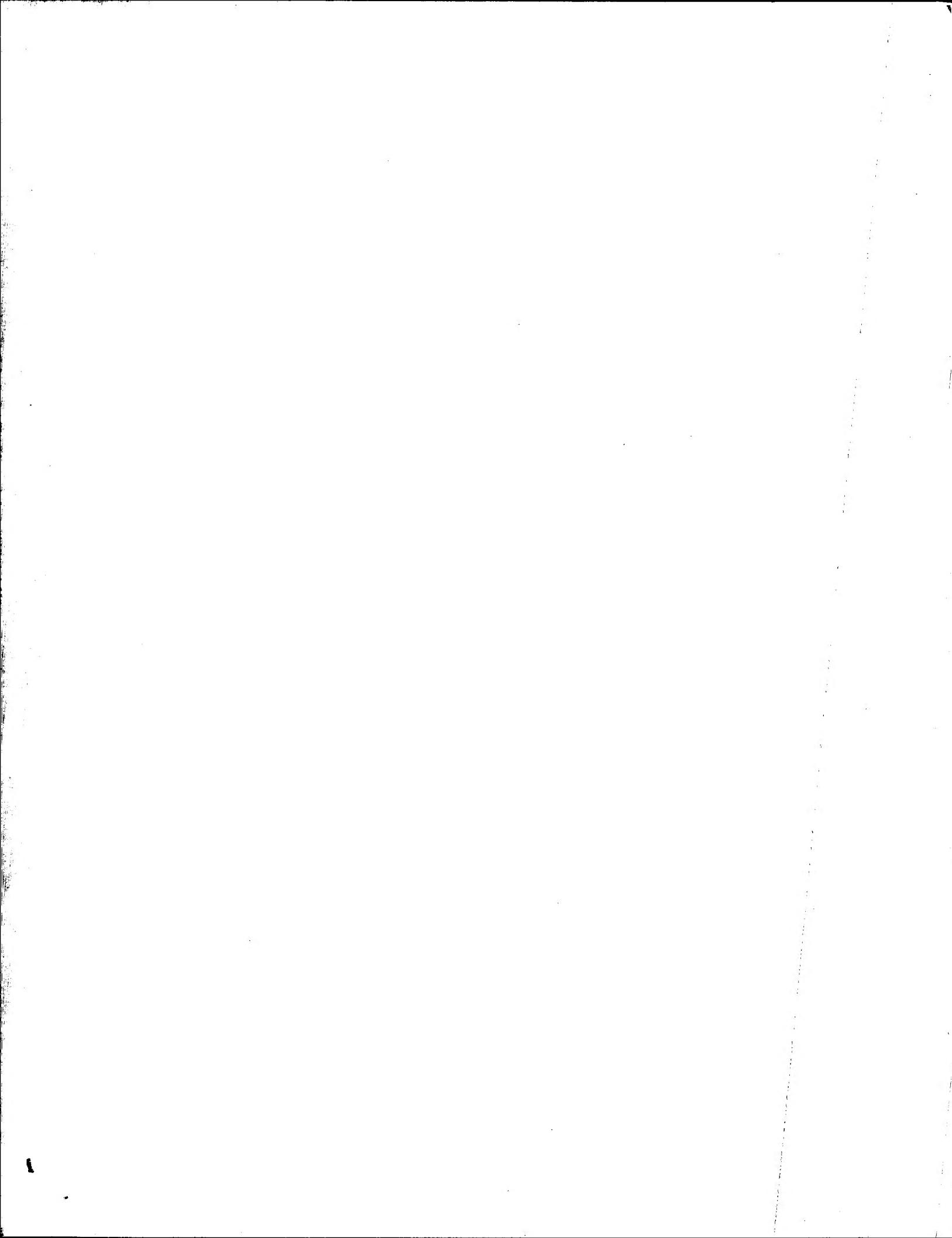
DART AEROSPACE LTD	Work Order:	28713
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>gml</u>	Audited by:	<u>J.L</u>	Prototype Approval:	<u>N/A</u>
Date:	<u>06/10/19</u>	Date:	<u>06/10/19</u>	Date:	<u></u>

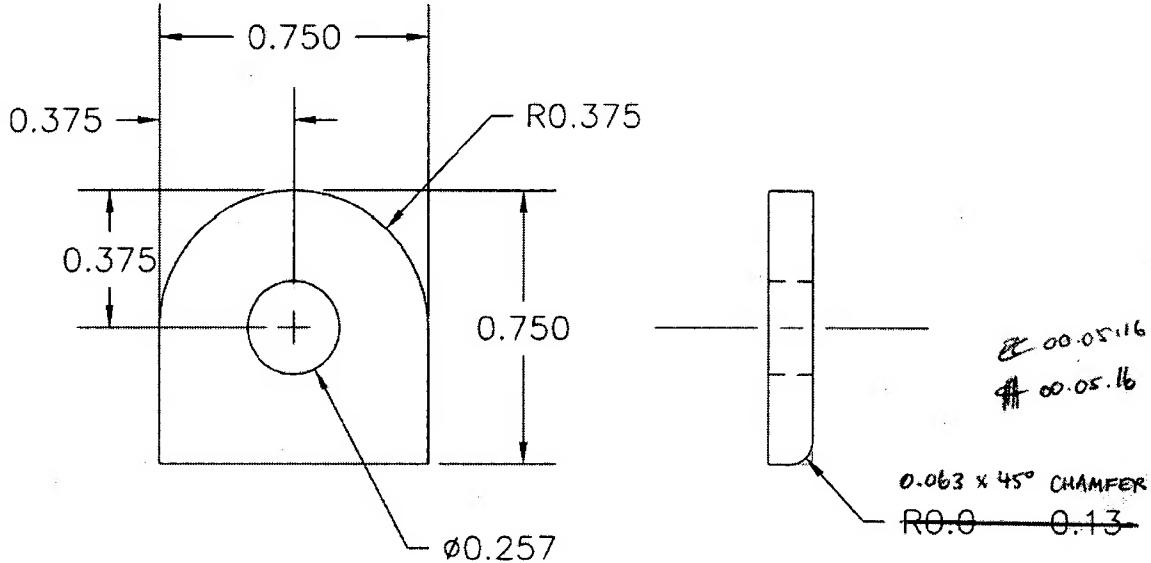
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	





DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>NOV</i>	APPROVED <i>GS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KG



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28713

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

